

Work Order ID 119494

Friday, May 16, 2014 12:51:43 PM

D 3 4 8 4 - 0 4 1

119494

Page 1

Item ID: D3484-041 B 1 1 9 4 9 4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tail Light Fairing Assembly, LH
 Start Date: 5/30/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-05-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 5 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3484	Rev F

100 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 24312
 Make as per Dwg D3484
 Material release note is required

CL 14/05/23 10

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging

10x 8/14/6-26

115 Weld per dwg A/R Aluminum rod Batch: _____ 0.00
 115
 Large Fab Memo 0.00
 Large Fab ***Touch up weld if necessary***

N/A PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 119494

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119494

Page 3

Item ID: D3484-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Light Fairing Assembly, LH
Start Date: 5/30/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/30/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00				10X			14/07/16
Quality Control									
160		0.00							
160									
Small Fab	Memo	0.00				10			FF 14-07-16
Small Fab	1-Install Nut Plates as per Dwg D3484								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00				10			
Quality Control									

DAS
36
989

DAS
27
9-59

14/7/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
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Material									
Operator									
Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 119494***119494***

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Friday, May 16, 2014 12:51:43 PM

Item ID: D3484-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Light Fairing Assembly, LH
Start Date: 5/30/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/30/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
200 Packaging	Memo	0.00							
Packaging	Identify as per dwg and Stock Location: <u>ST502</u>								
220	QC21- Final Inspection - Work Order Release	0.00							
220 QC	Memo	0.00							
Quality Control									

Handwritten notes:
10 14/7/16
MLJ 14-07-16
JMF 14-7-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>				Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Friday, May 16, 2014 12:51:47 PM

Page 1

Work Order ID: 119494

119494

Parent Item: D3484-041

D3484-041

Parent Item Name: Tail Light Fairing Assembly, LH

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-04-11 JLM
IPP Rev:B 08-01-24 chg rivet to CR1122-3-025 DD verf:EC IPP Rev:C
11.03.07 added weld touch up DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3484-041P		Purchased	No			110	Each	0.0000	1	10			
										**	10 x 8/14-6-26		
D3484-041P													
Tail light Fairing													
MS21069-04		Purchased	No			160	Each	27.0000	2	20			
										**	FF 14-07-16		
MS21069-04													
ANCHOR NUT													

Location Loc Qty Loc Code

ST277	15	
m128398	15	15
ST317	12	
124316	2	
m127580	10	5

CR1122-3-02.5	Purchased	No				160	Each	163.0000	4	40			
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CR1122-3-02 5

RIVET

**

FF 14-07-16

Location Loc Qty Loc Code

GA	30	
124762	30	
ST327	133	
m127432	133	40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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8

7

6

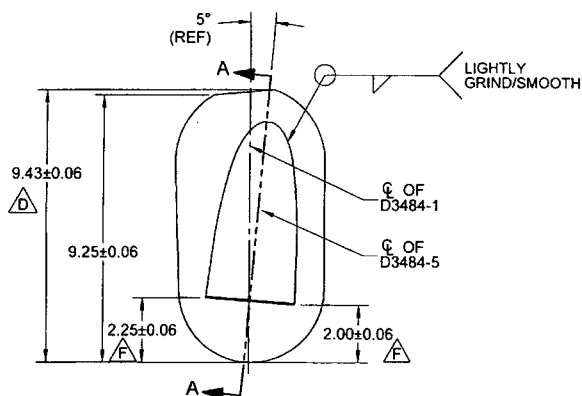
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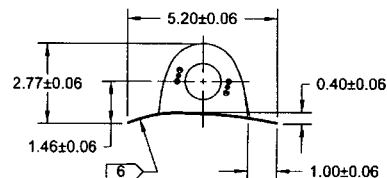
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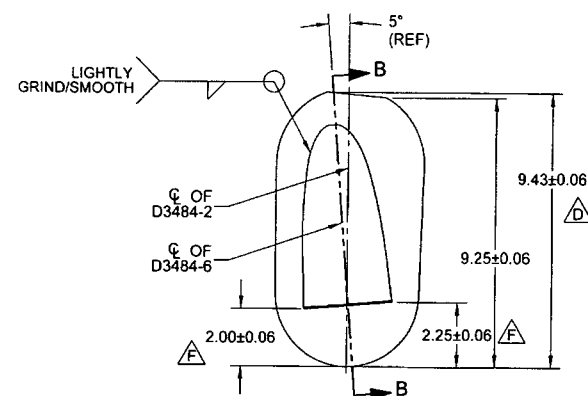


QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
1		D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
1		D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
1		D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



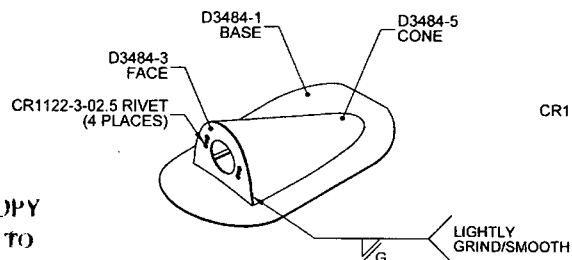
SECTION A-A

D3484-041 TAIL LIGHT FAIRING

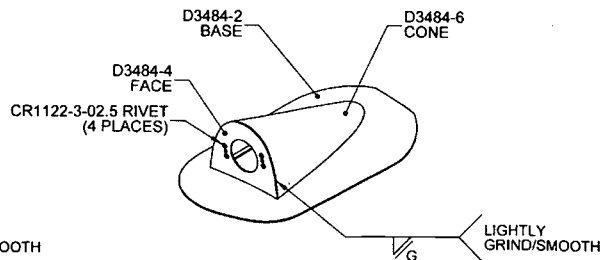
INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

RELEASED
09/03/31

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 119494 MJS

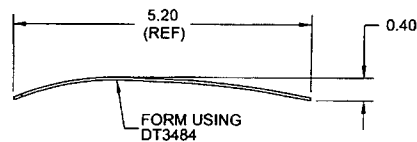
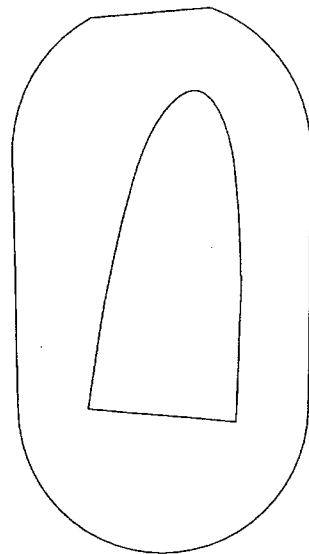
14-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"

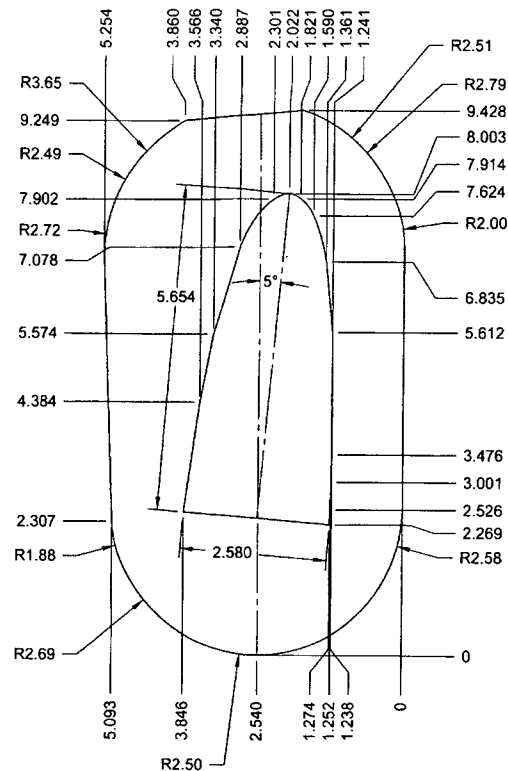
WEIGHT: 0.30 lbs

F	UPDATE MATERIAL SPEC, ADD 6061-0, ZN A7-2, A7-3, B3-4, UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1	MB	09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<div>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3484</div> <div>TITLE TAIL LIGHT FAIRING</div> <div>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>		
DRAWN			
CHECKED			
MFG. APPR.			REV. F
APPROVED			SHEET 1 OF 4
DE APPR.			SCALE
DATE		09.03.31	1:4

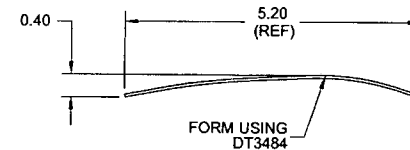
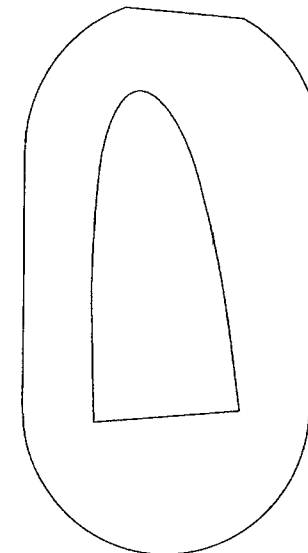


D3484-1 BASE
(MAKE FROM D3484-1F)

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs



D3484-1F BASE FLAT PATTERN

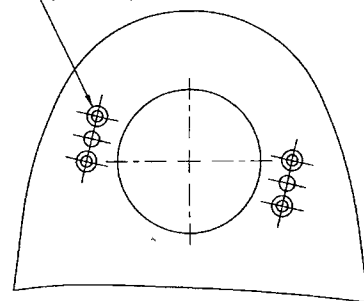


D3484-2 BASE
(MAKE FROM D3484-1F)

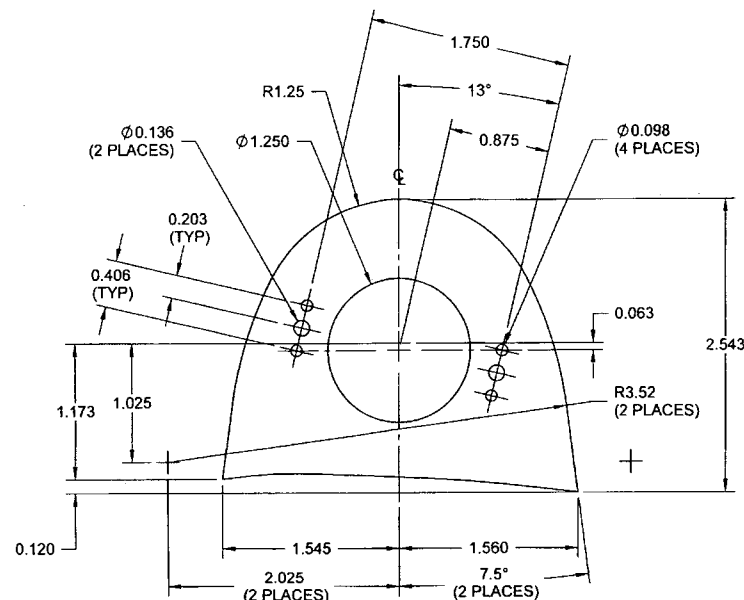
RELEASED
07/01/24/10

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D3484 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		TAIL LIGHT FAIRING 1:2
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD
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C'SINK
Ø0.181 X 100°
(4 PLACES)

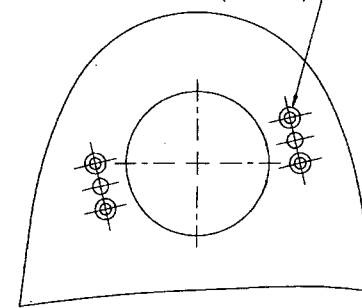


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø0.181 X 100°
(4 PLACES)









D3484-4 FACE
(MAKE FROM D3484-3F)

NOTES:

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
09/01/01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24312

Purchase Order Date 5/23/2014

PO Print Date 5/23/2014

Page Number 1 of 2

Order From :

VC-GFI001

Ship To : DART AEROSPACE LTD

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
05/23/2014

Contact Name

Vendor Phone 514 630 4877

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
Line Comments		Promise Date					
Delivery Comments							
1	D3484-041P	Tail light Fairing	6/17/2014		10.00	\$280.00	\$2,800.
			Yes		Each		
			6/17/2014				

AS PER DWG D3484 REV. F
B119494

FORMED & WELD AS PER QSI 005 CHEMICAL CONVERSION,
NUTPLATE AND POWDER COAT TO BE DONE AT DART

Line Total: \$2,800.

2	D3484-042P	Tail Light Fairing	6/17/2014		10.00	\$280.00	\$2,800.
			Yes		Each		
			6/17/2014				

AS PER DWG D3484 REV. F
B119779

FORMED & WELD AS PER QSI 005 CHEMICAL CONVERSION,
NUTPLATE AND POWDER COAT TO BE DONE AT DART

Line Total: \$2,800.

8214-6-24

Note:

5/23/2014



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO	PAGE
JR : DY	MO : MO	AN : YR		
20	06	14	0539573	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART GFI-0299	0286665	PO24312	

QUANTITE QUANTITY	N° DE PIÈCE PART NO	DESCRIPTION
10	D3484041P	TAIL LIGHT FAIRING ITEM 1 C OF C REQ'D
MFG. JOB# <u>50286665-001</u> QTY <u>10</u> pcs		
DUE DATE: <u>17 June 2014</u>		

EXPÉDITEUR
SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 10 OUR JOB NO J0286665 SHIPPING MEMO 0539573

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>10 PCS</u>	<u>PO24312</u>	<u>D3484041P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>	<u>F</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T0 (AMS-QQ-A-250/11)</u>		<u>TW METALS / KAISER ALUMINUM</u>		<u>656402A5</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>WELD FOLOWING PARTS TOGETHER PER DART QSI 004(1) D3484-1 (BASE LH),(1) D3484-3 (FACE LH),(1) D3484-5 (CONE LH)</u>	<u>GFI</u>	<u>N/A</u>
3	<u>REF. GFI MANUFACTURING JOB NUMBER J0286665-001 (10 PCS)</u>		
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 20 JUNE 2014

G.F.I. Q.C. REP.



[Signature]



ORDER NO.: 70546233

FROM: ATLA

PAGE 1

CUST NUMBER: 1203148

NET WGT:

68.152 REQ. DATE: 06/11/14 CONFIRMED

SOLD TO:

SHIP TO:

GFI INC

GFI INC

180 AVE. LABROSSE

180 AVE LABROSSE

POINTE CLAIRE QC

PIONTE CLAIR QC

CANADA

CN H9R 1A1

CANADA

CN H9R 1A1

SALESPERSON:

DEANNA PIMM

SHIP BY:

06/05/14

TERMS:

1% 10 NET 30

VIA:

COM CAR-SPECIF

F.O.B.:

SHIPPING POINT

FREIGHT:

COLLECT

CUST ORD NO.:

0084310

RELEASE NO.:

RECEIVING PHONE: 514 630-4877

LINE ITEM DESCRIPTION

WIDTH

LENGTH

0001 76409 60610 ALM SHT STENCILLED .0500

48

144

ORD QTY

INVOICE QTY

SHIPPED QTY

WT

PCS

2.000 EA

68.152 LB

68.152 LB

68.152

2

PART#: AS05148144PM

** 1 TEST REPORTS REQUIRED **

** 1 CERTS REQUIRED **

ECCN: EAR99

Export License: NLR

Expiration Date: 0/00/00

PO:49306569 HT:656402A5

PC: 2

CUSTOMER QTY:

UOM

MLT:UNITED STATES MFG:UNITED STATES

SLB/CL:KAISER*34.076#EA*

SHIP VIA UPS-SCS DEFERED ACCT# 543483804 OR YELLOW COLLECT
CLEAR CUSTOMS THRU CONSIGNEE'S BROKER: DHL GLOBAL FORWARDING
ISABELLE 514-734-4534 OR SYLVAIN 514-734-4527
FAX 514-344-8705

SHIP TO:
TW METALS
1200 BLAKE DRIVE
WICHITA, KS 67219

SOLD TO:
TW METALS INC
THE ARBORETUM
760 CONSTITUTION DRIVE
EXTON, PA 19341

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4326313

CUSTOMER PO NUMBER: M49306569		WORK PACKAGE:		CUSTOMER PART NUMBER: 76409		SHIP RUN/LOAD: 102866/7		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1164776	LINE ITEM: 1	SHIP DATE: 5-MAR-2014	ALLOY: 6061	CLAD: BARE	TEMPER: O	PRODUCT DESCRIPTION: HT Flat Sheet			
WEIGHT SHIPPED: 8492 LB	QUANTITY: 251 PCS EST.	TRUCK B/L #: 2046715	GAUGE: 0.0500 IN (1.2700 MM)		DIAMETER/WIDTH: 48.000 IN (1219.2 MM)		LENGTH: 144.000 IN (3657.6 MM)		

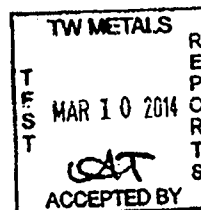
MHU 1749653: LOT 656402A5: 118 pieces;
MHU 1762050: LOT 656494A2: 133 pieces;

Certified Specifications

AMS 4025/RevL
CMMP 025/RevU

ASTM B 209/Rev10

CMMP 019/RevD



Test Code: 1925

Test Results

Lot: 656402A5 Cast 023

Drop 78

Ingot 2

Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	18.6 : 18.7 (128 : 129)	7.4 : 7.5 (51 : 52)	25.3 : 25.8
	T42	LT / 2 (Min:Max)	35.2 : 35.8 (243 : 247)	17.6 : 17.9 (121 : 123)	22.9 : 25.0
	T62	LT / 2 (Min:Max)	45.2 : 45.5 (312 : 314)	37.6 : 38.1 (259 : 263)	13.4 : 13.4

(ASTM E1251)
Chemistry:
Actual(wt%)

SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
0.71	0.5	0.31	0.08	1.1	0.18	0.06	0.02	0.01	0.00	TOT 0.05



KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4326313

Lot: 656494A2 Cast 023 Drop 87 Ingot 1 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	18.2 : 18.3 (125 : 126)	7.5 : 7.7 (52 : 53)	24.9 : 25.7
	T42	LT / 2 (Min:Max)	37.1 : 37.5 (256 : 259)	18.5 : 18.8 (128 : 130)	23.1 : 24.1
	T62	LT / 2 (Min:Max)	47.3 : 50.3 (326 : 347)	41.2 : 43.3 (284 : 299)	12.9 : 13.2

(ASTM E1251)	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Chemistry:											
Actual(wt%)	0.77	0.5	0.32	0.07	1.1	0.19	0.08	0.03	0.01	0.00	TOT 0.05

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061												
MIN(wt%)	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

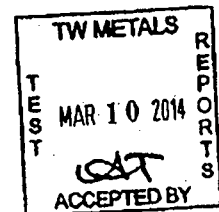
Aluminum Remainder

ORDER COMMENTS

FAR BAA (FAR 52.225-1 BUY AMERICAN
ACT-SUPPLIES)
DFARS BAA (DFARS 252.225-7001 BUY
AMERICAN ACT & BAL. OF PAYMENTS PROG
FAR TAA (FAR 52.225-6 TRADE AGREEMENTS)

TEST NOTES

6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS
4027 also meets applicable requirements of AMS-QQ-A-250/11,
Rev. A.



CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO-9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:
• has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
• was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
• has been thermally processed in compliance with AMS 2772, where applicable.
• is mercury free, within the limits of detection of ASTM E1251 (< = 1ppm).
• is in compliance with RoHS 2, European Union Directive 2011/85/EU.
• is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
• is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

James Hemenway

JAMES HEMENWAY, LABORATORIES SUPERVISOR

